



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2530

Job Sheet 202058



DAS
24
9-89 10

Part No: D2530

Job Qty: 4 pcs

Part Name: Handle Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 11/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	11/8/19		0.12	0.78	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 5	4 pcs	11/8/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S224409



Part: D2530

Job No: 202058

Serial No/Batch: S224409

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/21/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DAS
24
9-89

Plex 10/18/19 9:31 AM Dart.lajeunesse.marie

10/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 Large Fab - Welded Assy-2-B4B	4 pcs	11/8/19	0.00 1.60	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
130 QC 9	4 pcs	11/8/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
140 QC 5	4 pcs	11/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Powdercoat - 4 Black Sand - B4B	4 pcs	11/8/19	0.00 0.15	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	11/8/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	

DAS
24
9-89

B

B

BD 19-11-01.

M.156440
START: 9:50 - O.V.T. 300° FINISH: 10:20.DAS
68
9-89

NOV 04 2018

Plex 10/18/19 9:31 AM Dart.lajeunesse.marie

170 Packaging 3-1 - Stock - B4B	4 pcs	11/8/19	0.00 0.00	QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	FP-001 28 19-11-4
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	11/8/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg) 1-Cut to length as per Dwg D2530
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	11.4600 ft (2.865 ea)	100-Large Fab - Welded Assy-1	5 194865
D2534	Lock Plate	8 pcs (2 ea)	120-Large Fab - Welded Assy-2- B4B	520943 520 5526

Plex 10/18/19 9:31 AM Dart.lajeunesse.marie

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304TR0.750W.049	11	129	0
120-Large Fab - Welded Assy-2- B4B	D2534	8	55	0
Part Specifications				
Specifications could not be found.				

Plex 10/18/19 9:31 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)							
Description Work Order Deviation				Disposition							

Root Cause		FAULT CATEGORY											
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong					
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance					
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing					
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish					
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing					
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread					
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up							
Human Factors		Other/Details: _____											

Completed By	
Lead hand / Supervisor	
QC / QA Coordinator	